

**\*103894\***

Wednesday, July 03, 2013 12:38:24 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*12\***

**Cust Item ID:**

**\*12\***

**Customer:**

**Reference:**

**Approvals:**

**Process Plan:**

**Date:**

**Tooling:**

Date:

Run Start \*NR1\*

**QC:**

Date:

**SPC (Y/N):****Date:**

Stop \*NR2\*

[illegible]

# Work Order ID 103894

**\*103894\***

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Item ID: DSK078 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: D2893-1 TURNING DETAIL  
 Start Date: 7/3/2013 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 7/19/2013 Req'd Qty: 12.00 **\*12\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging	Identify and Stock in Kanban Location: <u>MAT 60</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

*only 13/07/08*

*13/7/8*

*113-07-8*

# Picklist Print

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Work Order ID: 103894

Parent Item: DSK078

Start Date: 7/3/2013

Required Date: 7/19/2013

Parent Item Name: D2893-1 TURNING DETAIL

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-005 Round Billet, 17-4		Manufactured	No				Each	13.0000		12			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT043	13	
101777	10	
94448	1	
97590	2	

x 4
x 1
x 2

13.7.5 1 DAS  
04  
9-89

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	103899
<b>Description:</b> Turning Detail for D2893-1		<b>Part Number:</b>	DSK078
<b>Inspection Dwg:</b> DSK078		<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
<b>Lathe Section</b>								
A	2.707	2.712		2.707	2.707	2.707	2.707	2.707
B	4.946	4.966		4.955	4.955	4.955	4.955	4.955
C	3.064	3.084		3.076	3.076	3.076	3.076	3.076
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.098	.098	.098	.098	.098
F	2.934	2.954		2.946	2.946	2.946	2.946	2.946
G	2.166	2.186		2.175	2.175	2.175	2.175	2.175
H	3.890	3.910		3.903	3.903	3.903	3.903	3.903
I	0.914	0.934		.924	.924	.924	.924	.924
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.120	.120	.120	.120	.120
L								
M								
N								
O								
P								

DAS  
04  
9-89

<b>Measured by:</b>	<b>Date:</b> 3.4.5
<b>Audited by:</b>	<b>Date:</b> 13/07/08
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	103894
<b>Description:</b> Turning Detail for D2893-1		<b>Part Number:</b>	DSK078
<b>Inspection Dwg:</b> DSK078 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
                         
 ☐ **Prototype**

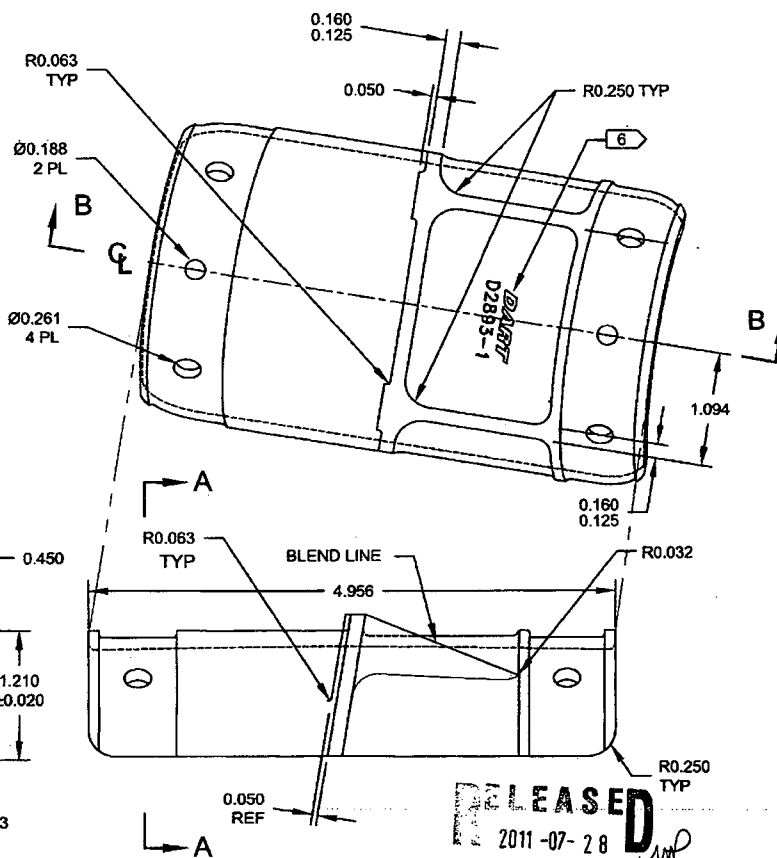
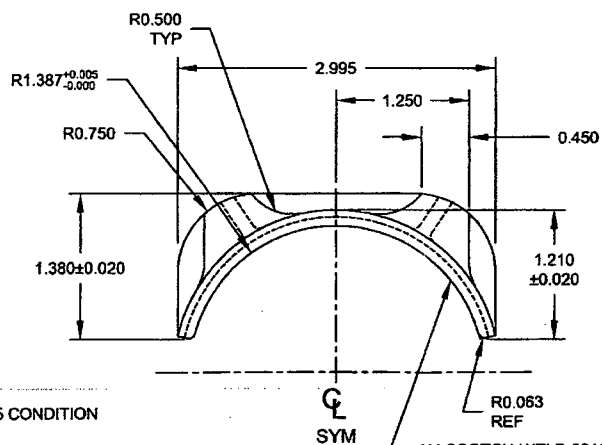
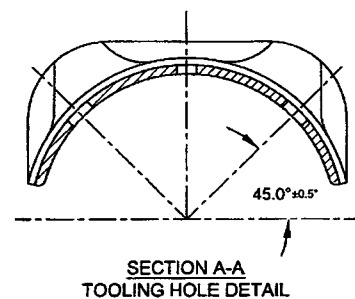
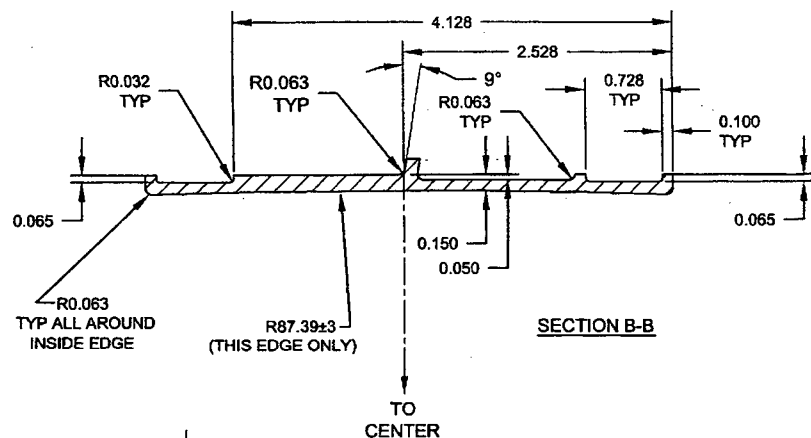
				Record Actual Dimensions				
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<b>Lathe Section</b>								
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J	0.022	0.042		.032	.032			
K	0.109	0.129		.120	.120			
L								
M								
N								
O								
P								

**Measured by:** DAS
**Date:** 13.4.5

**Audited by:** [Signature]
**Date:** 13/07/08

**Prototype Approval:**  
**Date:**  

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM [Signature]	[Signature]



#### NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION  
MIN UTS = 170 KSI (38 HRC)  
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP, PER DART QSI 044 6.3:
- 7) WEIGHT: 0.78 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:  
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

#### D2893-1 SUPPORT

0213/07/03  
W10: 103844

REV.	DESCRIPTION	BY	DATE
C	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION	CP	11.07.15
B	UPDATE DIMS AS MFG, PRIME INSIDE	PH	07.03.16
A	NEW ISSUE	CP	01.01.10
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	REV. C		
CHECKED	SHEET 1 OF 1		
MFG. APPR.	SCALE		
APPROVED	TITLE		
DE APPR.	02.750 SUPPORT		
DATE	11.07.15		

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